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 07.06.84-GB-014526 (18.10.85) B29c-53/38 F161-59/2
 Mfg. tube of microporous thermal insulation - by wrapping insulating
 slab with skin membrane around mandrel and securing
 C85-137532 E(BE DE FR GB IT SE)

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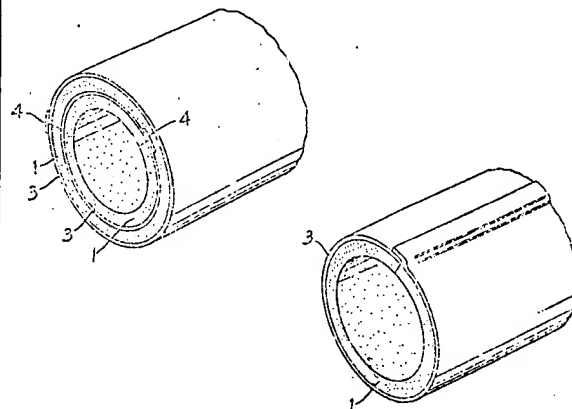
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A tube is made by placing on one surface of a flat slab of the material a membrane to form an outer skin, wrapping the assembly around a mandrel with the slab ends abutting, and securing the ends together.

The material is pref. compressed to a density of 150-400 kg/m³ to form the slab which has a thickness of 1-5mm, and the membrane is a tape or sheet of paper, plastics, woven fabric or metal foil and may be self-adhesive. The membrane is pref. overlapped onto and secured to itself, or an adhesive strip may be fixed along its edges. A second skin may similarly be formed on the opposite side of the slab. The outer membrane may extend beyond the tube ends and be wrapped around the ends and into the bore.

ADVANTAGE

Allows tubes of unrestricted length to be produced.
 (12pp1358KJPDwgNo2,5/5).



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(54) Method of manufacturing tubes of microporous thermal insulation material and tubes made by such method.

(57) A tube of microporous thermal insulation material is manufactured by compacting the microporous material to a slab (1) having a density of about 150 – 400 Kg/m³ and a thickness of about 1 to 5 mm, applying to one surface of the slab a membrane (3), for example of self-adhesive aluminium foil, wrapping the slab around a mandrel so that the ends of the slab abut substantially against each other and securing the ends of the slab relative to each other, for example by means of a protruding flap of the aluminium foil.

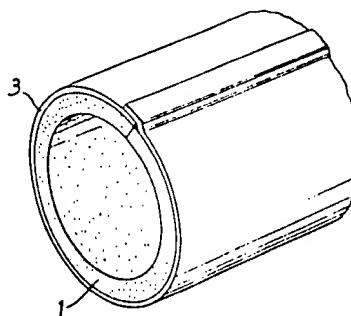


Fig. 2

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METHOD OF MANUFACTURING TUBES OF MICROPOROUS THERMAL INSULATION
MATERIAL AND TUBES MADE BY SUCH METHOD

5 The present invention relates to a method of manufacturing tubes of microporous thermal insulation material and to tubes made by such method. More particularly, but not exclusively, the present invention relates to tubes which have relatively thin walls.

10

It is well known to manufacture slabs and other simple shapes from microporous thermal insulation material by compacting the material in a die. This method produces a block of material which has an
15 exceptionally low thermal conductivity but which is handleable only to a very limited extent because the material is relatively friable. It is therefore generally considered that the only post-forming operations which can be carried out on the material must be carried out by machining. For example, any attempt to bend the material
20 will cause it to crack, but it may be cut to size and holes or depressions may be machined by suitable means.

Sample shapes which may be moulded include tubes, which may be formed using a die in the shape of an annulus. However, it has been found that there is a limit to the size of tube which can be formed in this way. Because of friction, the tubes do not have uniform density, but are relatively more dense in the region close to the compacting die and are relatively less dense in the region remote from the compacting die. When the wall thickness of the tube is small, the variation in density becomes a severe problem and thin walled tubes can only be made in very short lengths.

10

It is an object of the present invention to provide a method of manufacturing tubes of microporous thermal insulation material which are not restricted as to length.

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According to one aspect of the present invention there is provided a method of manufacturing a tube of microporous thermal insulation material, which method comprises the steps of:

20

forming a substantially flat slab of microporous thermal insulation material;

25

providing on one surface of the slab a membrane which is to form the outer skin of the tube to be produced;

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wrapping the slab and the membrane around a mandrel having a diameter corresponding to the internal diameter of the tube to be produced such that the ends of the slab abut substantially against each other and

securing the ends of the slab relative to each other.

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According to another aspect of the present invention there is provided a tube of microporous thermal insulation material which comprises a slab of microporous thermal insulation material which is formed into the shape of an annulus with the ends of the slab abutting substantially against each other, and an outer skin which extends around the annulus so as to secure the ends of the slab relative to each other.

For a better understanding of the present invention and to show more clearly how it may be carried into effect reference will now be made, by way of example, to the accompanying drawings in which:

Figure 1 is a diagrammatic representation of a stage in one embodiment of a method of producing a tube of microporous thermal insulation material according to the present invention;

Figure 2 shows one embodiment of a tube of microporous thermal insulation material according to the present invention;

Figure 3 shows another embodiment of a tube of microporous thermal insulation material according to the present invention;

Figure 4 shows an embodiment of a tube according to the present invention in which an outer skin is wrapped around the ends of the tube; and

Figure 5 shows an embodiment of a tube according to the present invention in which a further layer of microporous thermal insulation material is wrapped upon a base layer.

In order to produce a tube of microporous thermal insulation according to the present invention, a first step is to form insulation material

An intimate mixture is formed from a finely divided powder, opacifier, if needed, and reinforcing fibre. The finely divided material may be, for example, pyrogenic silica, carbon black, finely divided metal oxide such as alumina or titania. The material may be a radiation scattering material having a high refractive index such as titania, alumina, zirconia, iron oxide or chromium oxide, a radiation absorbing material such as carbon black or a reflecting material such as a metal. The opacifier may be in the form of a powder, short fibres or flakes. The reinforcing fibre may be, for example, ceramic fibre, glass fibre or other inorganic fibre and should have a minimum length of about 2 mm.

The relative proportions of the various materials depend on the intended use of the thermal insulation tube. For example, the temperature at which the insulation material is to be used, the higher will be the proportion of opacifier used. However, the proportion of finely divided powder is typically about 40 per cent by weight, the proportion of opacifier is typically 10 per cent by weight and the proportion of reinforcing fibre is 10 to 50 per cent by weight. A preferred insulation material consists of about 63 per cent by weight finely divided powder, 30 per cent by weight opacifier and 7 per cent by weight reinforcing fibre.

The intimate mixture is placed in a die and is compressed to a density generally in the range from 150 to 400 kg/m³ to form a flat slab of microporous thermal insulation material having a thickness typically in the range from 1 to 5 mm.

As can be seen from Figure 1, the slab 1 of microporous thermal insulation material, which is dimensioned so that it will conveniently wrap around a mandrel 2 of diameter equivalent to the internal diameter of the tube to be produced, is placed on a membrane 3 of material which is to form an outer skin of the tube to be produced.

The membrane 3 may be made from a sheet of any suitable material and is chosen, for example, so as to obtain a desired rigidity of the tube of insulation material. The membrane may be, for example, a self-adhesive tape or sheet of paper, plastics material, woven fabric or metal foil. It is not essential that the membrane should be self-adhesive because alternative methods of securing the ends of the slab may be employed.

The slab of insulation material and the membrane are wrapped around the mandrel, and the membrane is maintained in close contact with the insulation material, for example, by overlapping the membrane onto itself and by gluing the membrane to itself, by fixing an adhesive strip 4 along the edges of the membrane as shown in Figure 3, or by passing a sleeve over the membrane (not shown).

When it is removed from the mandrel, the resulting tube is found to be unexpectedly robust and handleable.

In cases where a skin is required on the inside of the tube of microporous thermal insulation material, such skin can be provided as shown in Figure 3 by positioning a membrane 5 of suitable material around the mandrel before the slab 1 is wrapped around the mandrel.

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5 The ends of the tube are relatively friable and it may in some cases
be considered desirable to protect the ends of the tube. This may be
accomplished, as shown in Figure 4 for example, by extending the
outer membrane 3, laterally beyond the ends of the tube and
subsequently wrapping the lateral portions of the membrane around the
ends of the tube and into the bore thereof. We have found that this
method is particularly satisfactory when the outer membrane comprises
a metal foil. However, other methods may be used such as applying a
glue, a cement or a polymeric material to the ends of the tube.

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The method described above may be used to produce tubes of
microporous thermal insulation material which have relatively thin
walls. Where thick walled tubes are required these may be made as
shown in Figure 5 by wrapping one or more further slabs of
microporous thermal insulation material upon the previous layer or
layers.

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CLAIMS:

1. A method of manufacturing a tube of microporous thermal insulation material, characterised in that the method comprises the steps of:
 - forming a substantially flat slab (1) of microporous thermal insulation material;
 - providing on one surface of the slab (1) a membrane (3) which is to form an outer skin of the tube to be produced;
 - wrapping the slab and the membrane around a mandrel (2) having a diameter corresponding to the internal diameter of the tube to be produced such that the ends of the slab abut substantially against each other; and
 - securing the ends of the slab relative to each other.
2. A method according to claim 1, characterised in that the microporous thermal insulation material is compressed to a density of about $150 - 400 \text{ Kg/m}^3$ in order to form the slab (1).
3. A method according to claim 1 or 2, characterised in that the slab (1) has a thickness of about 1 to 5 mm.
4. A method according to claim 1, 2 or 3, characterised in that the membrane (3) comprises a tape or sheet of paper, plastics material, woven fabric or metal foil.
5. A method according to claim 4, characterised in that the membrane (3) is self-adhesive.
6. A method according to any preceding claim, characterised in that the membrane (3) is maintained in close contact with the insulation material by overlapping the membrane onto itself and by securing the membrane to itself.

7. A method according to any one of claims 1 to 5, characterised in that the membrane (3) is maintained in close contact with the insulation material by fixing an adhesive strip (4) along the edges of the membrane.

5

8. A method according to any preceding claim, characterised in that a skin is provided on the inside of the tube by positioning a further membrane (5) around the mandrel (2) before the slab (1) is wrapped around the mandrel.

10

9. A method according to any preceding claim, characterised in that the membrane (3) extends laterally beyond the ends of the tube and the lateral portions are subsequently wrapped around the ends of the tube and into the bore thereof.

15

10. A method according to any preceding claim, characterised in that one or more further slabs (1) of microporous thermal insulation material are wrapped upon the previous layer or layers so as to increase the wall thickness of the tube.

20

11. A tube of microporous thermal insulation material characterised in that the tube comprises a slab (1) of microporous thermal insulation material which is formed into the shape of an annulus with the ends of the slab abutting substantially against each other, and an outer skin (3) which extends around the annulus so as to secure the ends of the slab relative to each other.

25

12. A tube as claimed in claim 11, characterised in that the slab (1) has a density of about $150 - 400 \text{ Kg/m}^3$.

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13. A tube as claimed in claim 11 or 12, characterised in that the slab (1) has a thickness of about 1 to 5 mm.

35

14. A tube as claimed in claim 11, 12 or 13, characterised in that the outer skin (3) comprises a tape or sheet of paper, plastics material, woven fabric or metal foil

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15. A tube as claimed in claim 14, characterised in that the outer skin (3) is self-adhesive.

5 16. A tube as claimed in any one of claims 11 to 15, characterised in that the outer skin (3) is overlapped onto itself and is secured to itself in order to maintain the outer skin in close contact with the insulation material.

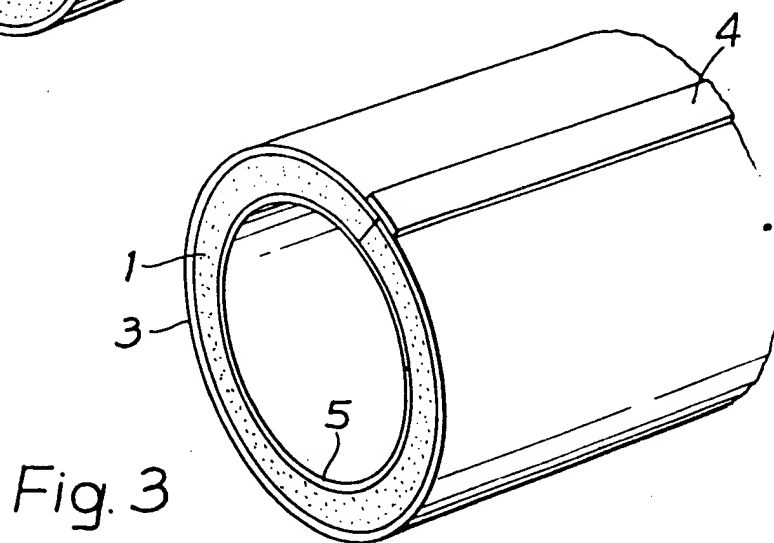
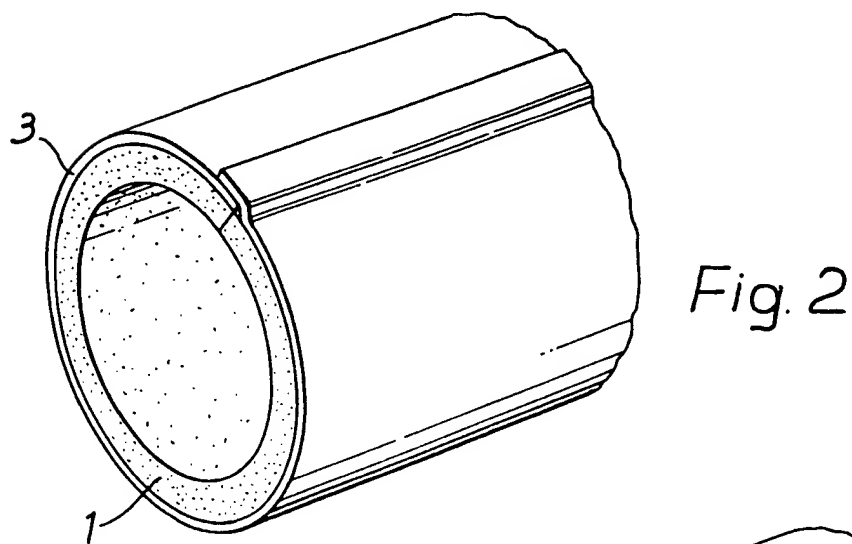
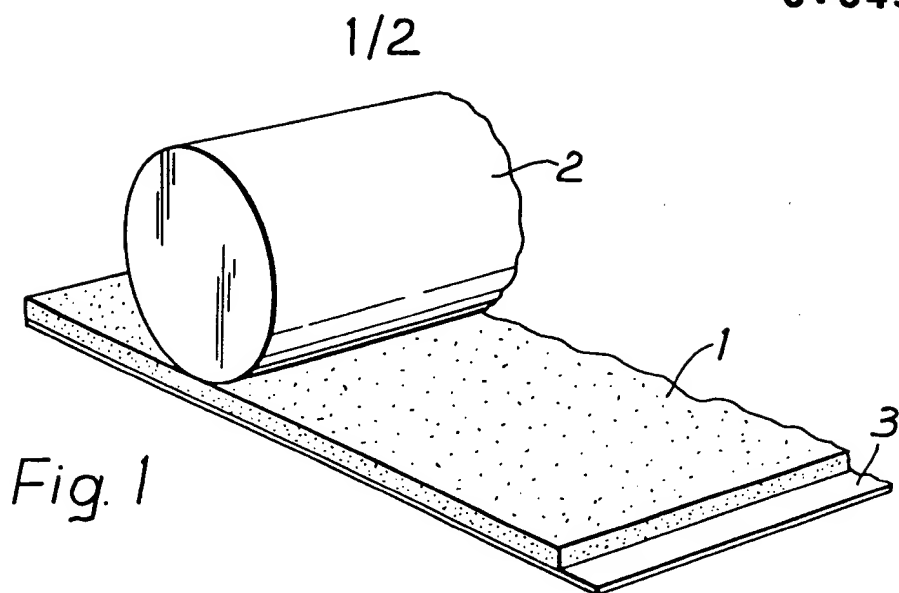
10 17. A tube as claimed in any one of claims 11 to 15, characterised in that an adhesive strip (4) is fixed along the edges of the outer skin (3) so as to maintain the outer skin in close contact with the insulation material.

15 18. A tube as claimed in any one of claims 11 to 17, characterised in that an inner skin (5) is provided on the inside of the tube.

19. A tube as claimed in any one of claims 11 to 18, characterised in that the outer skin (3) is wrapped around the ends of the tube and into the bore thereof.

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20. A tube as claimed in any one of claims 11 to 19, characterised in that the tube comprises one or more further slabs (1) of microporous thermal insulation material wrapped upon the previous layer or layers.



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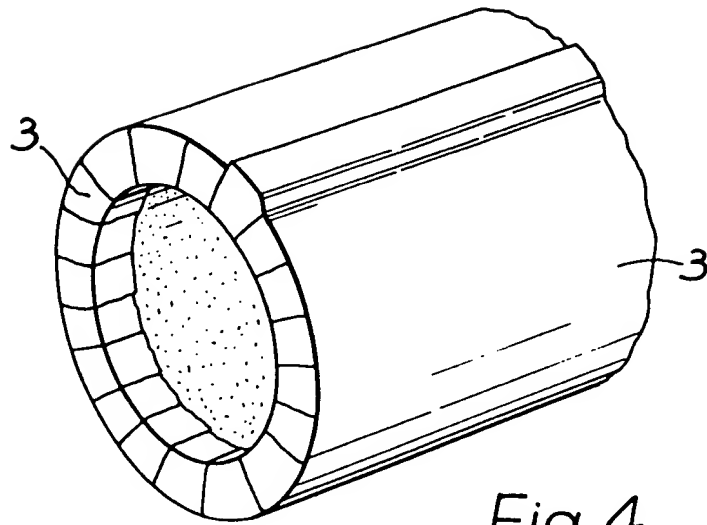


Fig. 4

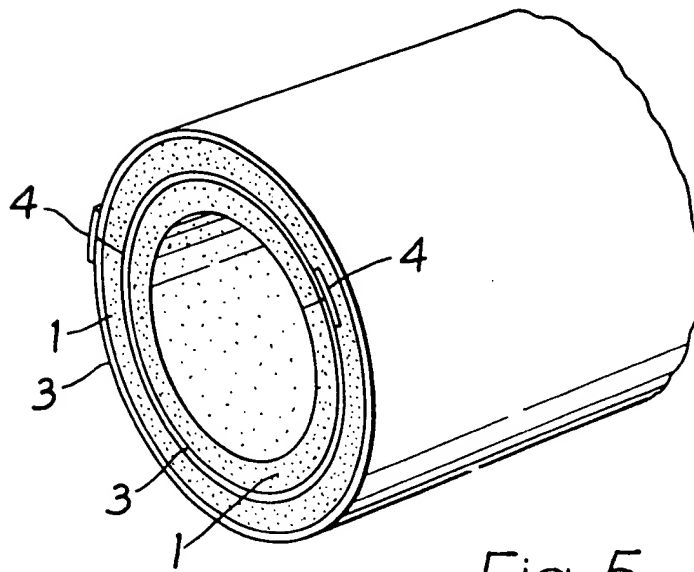


Fig. 5